

PHASE 2) PREPARATION OF PART FOR PAINTING & PAINT

For Vehicles equipped with factory hitch:

Using a sharp new razor blade cut part out along the INSIDE edge of the template molded into the part leaving the template intact. Prep as needed.

For vehicles equipped with factory back up sensors:

Locate on the inside of the bumper the circular template marks for the back up sensors. Using a 1-5/8 hole saw, cut out bumper templates and finish as needed.

1. SAND edges as necessary
2. WASH paintable surfaces and the tape ledge w/ 3M #7447 Scotchbrite pad, TSP, and warm water
3. SAND the paintable surfaces w/ 320 wet or dry- at this point the surface should appear to be a dull medium gray color, not shiny or black
4. CLEAN paintable surfaces with either Dupont 2319S or Sherwin Williams #R7K157 or #R7K158 or equivalent
5. FILL any slight surface imperfections, if applicable, with "Evercoat" glazing putty & sand smooth
6. APPLY 3/4" masking tape onto the inside tape ledge area (if applicable)
7. APPLY Dupont #2322 or Sherwin Williams P6C61 adhesion promoter or equivalent
8. APPLY basecoat/clearcoat following the paint manufactures recommendations for painting a flexible polyurethane type material

NOTE: Some painters prefer, after cleaning the surface, to apply Dupont "Variprime" or equivalent, let dry and scuff with the gray Scotchbrite pad or sand 600, clean and then paint DO NOT oven bake our parts above 130 degrees F. They should be well supported during this heat cycle to avoid the flexible part from warping.

PHASE 3) INSTALLATION OF THE 3M TAPE (If applicable)

1. If any paint overspray appears on the tape ledge, SAND all paint off.
2. Wipe the tape ledge twice with Acetone or MEK
3. Scratch the tape ledge with scotchbrite #7447 and MEK or Acetone. Then wipe the same area with MEK, followed by the 3M #4298 adhesion promoter (provided) or "Probond"
4. Apply the tape, making sure to pull it slightly, V-Cut as necessary going around curved areas and PRESS the tape on with the handle part of the scissors.
5. Allow the part to set with the tape applied, if possible for an hour or more in a warm area. This will help with the curing process.

PHASE 4) INSTALLATION OF THE PART (perform in a warm area above 70 degrees)

1. Clean Factory bumper with Acetone or MEK at all for proper adhesion of mounting tape (if applicable)
2. Remove Factory license plate lights from bumper and disconnect wire harness from back of light
3. Remove license plate and frame.
 1. Place Xenon part over factory bumper cover working from the center out.
 2. Pull part over ends of factory bumper and align with light openings in stock bumper
6. DRILL the forward facing edge of the bumper area in two places on each side and secure with #8 non-self tapping screws.
7. Re-install lights, license plate, and frame. Make sure to re-connect harness to lights.
8. Install bracket with large hole up. Remove bolt in bumper on either side of Trailer Ball hole.
9. Locate bracket against Xenon part and mark for drilling of 5/16 holes.
10. Drill Hole in Xenon part and secure to bracket with 5/16 nuts, bolts, and washers.
11. Review install and part alignment.

Sources for some of the referenced materials: MEK (Methyl Ethyl Ketone) can usually be purchased at a hardware store. Scotch-brite, glazing putty and TING can be purchased from automotive paint supply stores. TSP is usually available at your local grocery store located in the cleaning supplies section.

HARDWARE PROVIDED:

- (4) #8 x 3/4" non self-tapping screws
- (2) 3-3/8 Bumper Bracket
- (2) 5/16 Hex Head Bolts
- (2) 5/16 Nylock nuts
- (4) 5/16 Flat washers

FOR PART NUMBER (S): 11604 Rear Bumper Cover

DATE: Sept. 2003